

# Work Order ID 96821

February-07-13 8:19:26 AM

\*96821\*

Page 1

Item ID: D2896-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Support

Start Date: 2/07/13 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 2/21/13 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 13-02-07 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2896	C								

100

\*1000\*

HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

0.00

Memo

Machine as per Folio FA167

Folio Rev: B

Dwg Rev: C

13-04-03  
FK 13/04/04  
Off/BA 20130406

19  
20 Ø

Deburr

\*\*\*\*Program Batch #\*\*\*\*\*

\*PTU

110

\*110\*

QC

Quality Control

QC1- Inspect dimensions to dimension sheet

0.00

0.00

Memo

FK 13/04/04  
Off/BA 13/04/06

19  
20 Ø

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: AK Date: 13/65/05QA Closed: AK Date: 13/4/23

Work Order: <u>96821</u> Part No. <u>D2896-1</u> NCR No. <u>13.2533</u>				<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b> <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input checked="" type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	13.04.16	100	4	.625" bore not parallel to top of boss .008-.019"	GP 13/4/16	Straightness is 0.007" phy (1) SCRAP. 1/2 per dwg tolerance Remaining parts are acceptable GP 13/4/17	DAK 33 13.04.17	DAS 16 9-83 13/04/83	DAS 16 9-83 13/04/23
Equip/Tooling									
Operator									
Material									
Setup			20	.086" diam is .098-.101"					
Other									
Process									
Supplier									
Training									
Unapproved									

**FAULT CATEGORY**

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
---	---	---

294/100  
 13/4/17

<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Work Order ID 96821

February-07-13 8:19:26 AM

**\*96821\***

Page 2

Item ID: D2896-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Support

Start Date: 2/07/13 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 2/21/13 Req'd Qty: 20.00

**\*20\***


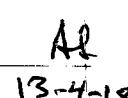
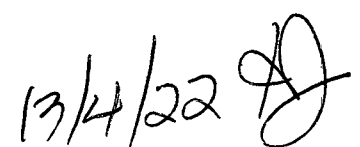
Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>						19	1		
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: <u>L653</u>	0.00							
<b>*130*</b>						19	1		
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

13-04-18

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions  <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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# Picklist Print

February-07-13 8:19:30 AM

Page 1

Work Order ID: 96821

\*96821\*

Parent Item: D2896-1

\*D2896-1\*

Parent Item Name: Support

Start Date: 2/07/13

Required Date: 2/21/13

Start Qty: 20.00

Required Qty: 20.00

## Comments:

IPP: B02.11.26Reformat; Added P/O; Added mask holeKJ

IPP Rev:C As per Rev B 07-04-16 JLM

IPP D 08.03.19 Re-format EC verified by DD

IPP REV:E

11.10.03 ASPER REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK080		Manufactured	No			100	Each	13.0000	0.5	10			
*DSK080*									**	10		11-13-04-03	
D2896-1 TURNING DETAIL													

## Location

## Loc Qty

## Loc Code

MAT060

13

89143

10

89632

3

9

1

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

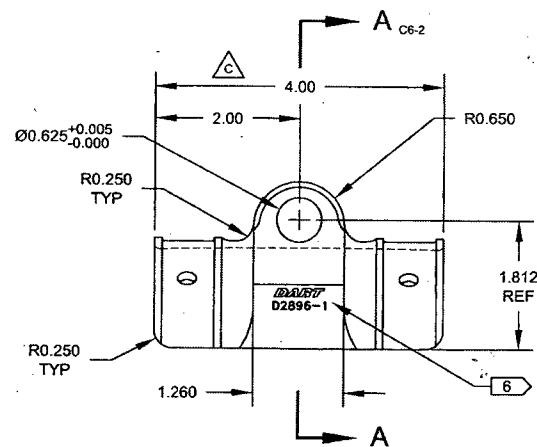
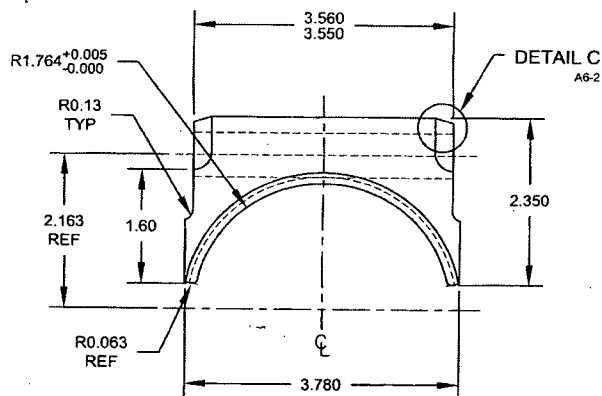
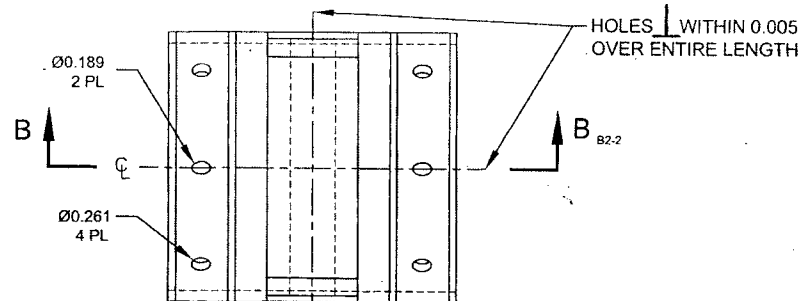
QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions  <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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D2896-1 SUPPORT

9.6821 MJS  
13-02-07

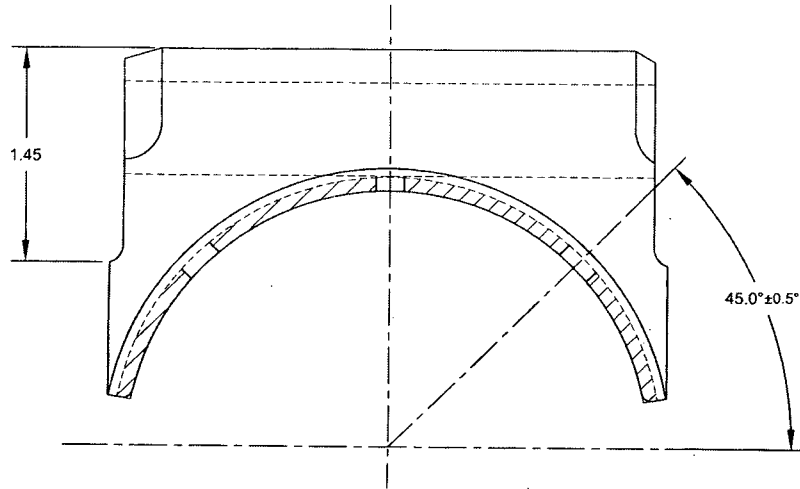
RELEASED  
2011-09-29

NOTES:

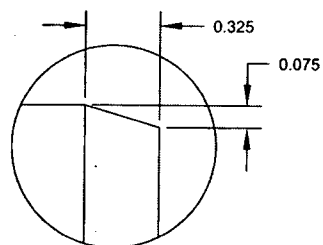
- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION PER ASTM A564 OR AMS 5643 OR AISI 630 MIN UTS = 170 KSI (38 HRC)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO AND P/N WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP PER DART QSI 044 6.3
- 7) WEIGHT: 1.76 lbs

C	RMV FINISH & UPDATE MAT'L SPEC (A8-1), 2.00 WAS 2.000, 4.00 WAS 4.000 (C4-1), REFORMAT DWG	CP	11.09.07
B	INCORP. A1-A4, FINISHING NOTES	PH	07.03.19
A	NEW ISSUE	CP	01.10.19
DESIGN	AP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	JMD	D2896	SHEET 1 OF 2
APPROVED	JMD	TITLE	SCALE
DE APPR.	JMD	SUPPORT	NTS
DATE	11.09.07	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

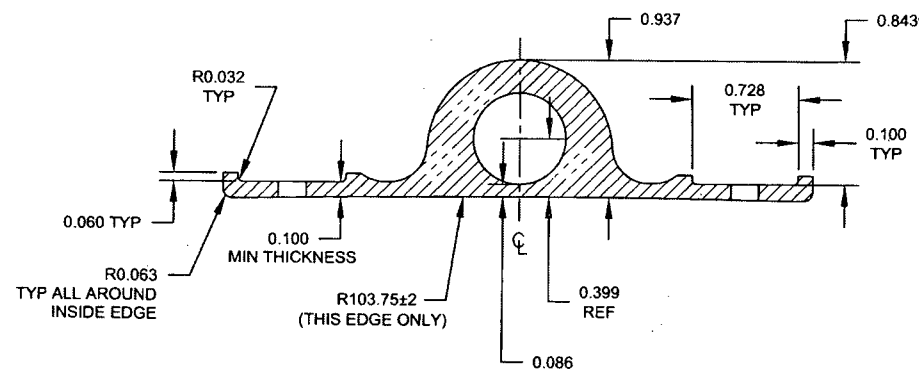
90821



**SECTION A-A** C3-1  
TOOLING HOLE DETAIL  
SCALE 2X



**DETAIL C** C6-1  
SCALE 4X



**SECTION B-B** D3-1  
SCALE 2X

**RELEASED**  
2011-09-29

DESIGN	JP	<b>DART AEROSPACE LTD</b>	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D2896	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT	NTS
DATE	11.09.07	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 96821
<b>Description:</b> Support		<b>Part Number:</b> D2896-1
<b>Inspection Dwg:</b> D2896	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
<b>HAAS Section</b>								
AA	2.152	2.172		2.163	2.163	2.163	2.163	2.163
AB	2.340	2.360		2.352	2.353	2.353	2.353	2.354
AC	3.550	3.560		3.556	3.557	3.556	3.556	3.555
AD	3.770	3.790		3.777	3.777	3.780	3.782	3.781
AE	0.065 x 0.315	0.085 x 0.335		0.075 x 0.325	0.075 x 0.325	0.075 x 0.335	0.075 x 0.335	0.075 x 0.335
AF	1.42	1.48		1.445	1.445	1.451	1.452	1.451
AG	0.833	0.853		0.840	0.849	0.846	0.839	0.846
AH	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AI	0.261	0.266		0.261	0.261	0.261	0.261	0.261
AJ	0.189	0.194		0.189	0.189	0.189	0.189	0.189
AK	1.970	2.030		2.001	2.000	2.000	2.000	2.000
AL	0.625	0.630		0.625	0.625	0.625	0.625	0.627
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AO	0.926	0.946		0.940	0.940	0.939	0.939	0.936
AP								
AQ								
AR								
<b>Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"</b>								
<b>Accept/Reject</b>				0.001	0.001	0.001	0.005	0.0025

<b>Measured by:</b> FK D46	<b>Date:</b> 13/04/04
<b>Audited by:</b> 33	<b>Date:</b> 13-04-07
<b>Preliminary Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	
F	12.07.31	Dimensions updated per Dwg Rev C	KJ	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	96821
<b>Description:</b> Support		<b>Part Number:</b>	D2896-1
<b>Inspection Dwg:</b> D2896	<b>Rev:</b> C	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
<b>HAAS Section</b>								
AA	2.152	2.172		2.163	2.163	2.163	2.163	2.163
AB	2.340	2.360		2.354	2.356	2.356	2.357	2.350
AC	3.550	3.560		3.555	3.555	3.555	3.553	3.551
AD	3.770	3.790		3.785	3.781	3.780	3.781	3.780
AE	0.065 x 0.315	0.085 x 0.335		0.075 x 0.335	0.075 x 0.335	0.075 x 0.335	0.075 x 0.335	0.075 x 0.335
AF	1.42	1.48		1.450	1.449	1.450	1.450	1.450
AG	0.833	0.853		0.840	0.846	0.841	0.842	0.847
AH	0.240	0.260		R.0.250	R.0.250	R.0.250	R.0.250	R.0.250
AI	0.261	0.266		0.263	0.263	0.263	0.263	0.263
AJ	0.189	0.194		0.191	0.191	0.191	0.191	0.191
AK	1.970	2.030		2.000	2.000	1.998	2.003	2.002
AL	0.625	0.630		0.627	0.627	0.627	0.627	0.627
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AO	0.926	0.946		0.938	0.940	0.937	0.937	0.942
AP								
AQ								
AR								
<b>Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"</b>								
<b>Accept/Reject</b>				0.0025	0.001	0.0025	0.0025	0.0025

<b>Measured by:</b>	Fk D4 332	ofc/b.a	<b>Date:</b>	13/09/05
<b>Audited by:</b>	332		<b>Date:</b>	13.04.07
<b>Preliminary Approval:</b>			<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	
F	12.07.31	Dimensions updated per Dwg Rev C	KJ	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	96821
<b>Description:</b> Support		<b>Part Number:</b>	D2896-1
<b>Inspection Dwg:</b> D2896	<b>Rev:</b> C	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
<b>HAAS Section</b>								
AA	2.152	2.172		2.163	2.163	2.163	2.163	2.163
AB	2.340	2.360		2.351	2.352	2.352	2.351	2.351
AC	3.550	3.560		3.555	3.555	3.554	3.552	3.554
AD	3.770	3.790		3.779	3.782	3.780	3.775	3.780
AE	0.065 x 0.315	0.085 x 0.335		0.075 x 0.335	0.075 x 0.335	0.075 x 0.335	0.075 x 0.335	0.075 x 0.335
AF	1.42	1.48		1.449	1.447	1.447	1.452	1.446
AG	0.833	0.853		0.844	0.842	0.843	0.845	0.846
AH	0.240	0.260		R0.250	R0.250	R0.250	R0.250	R0.250
AI	0.261	0.266		0.263	0.263	0.263	0.263	0.263
AJ	0.189	0.194		0.191	0.191	0.191	0.191	0.191
AK	1.970	2.030		1.998	1.999	2.000	1.998	2.000
AL	0.625	0.630		0.627	0.627	0.627	0.627	0.627
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AO	0.926	0.946		0.939	0.941	0.939	0.939	0.939
AP								
AQ								
AR								
<b>Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"</b>								
<b>Accept/Reject</b>				0.001	0.002	0.001	0.004	0.005

<b>Measured by:</b> JFC/D.A.	<b>Date:</b> 2013-04-08
<b>Audited by:</b> D.S. 325	<b>Date:</b> 13-04-17
<b>Preliminary Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	
F	12.07.31	Dimensions updated per Dwg Rev C	KJ	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	96821
<b>Description:</b> Support		<b>Part Number:</b>	D2896-1
<b>Inspection Dwg:</b> D2896		<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	17	18	19	20
<b>HAAS Section</b>								
AA	2.152	2.172		2.163	2.163	2.163	2.163	2.163
AB	2.340	2.360		2.353	2.354	2.355	2.355	2.354
AC	3.550	3.560		3.553	3.553	3.553	3.554	3.554
AD	3.770	3.790		3.780	3.781	3.781	3.775	3.775
AE	0.065 x 0.315	0.085 x 0.335		0.075 x .335	0.075 x .335	0.075 x .335	0.075 x .335	0.075 x .335
AF	1.42	1.48		1.446	1.446	1.446	1.446	1.446
AG	0.833	0.853		0.843	0.845	0.846	0.842	0.846
AH	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AI	0.261	0.266		0.261	0.261	0.261	0.261	0.261
AJ	0.189	0.194		0.189	0.189	0.189	0.189	0.189
AK	1.970	2.030		2.000	2.000	2.000	2.000	2.000
AL	0.625	0.630		0.627	0.625	0.625	0.625	0.625
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AO	0.926	0.946		0.939	0.939	0.939	0.939	0.939
AP								
AQ								
AR								
<b>Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"</b>								
<b>Accept/Reject</b>				0.001	0.001	0.0045	0.001	0.001

<b>Measured by:</b> F.K.	<b>Date:</b> 13/04/09
<b>Audited by:</b> [Signature]	<b>Date:</b> 13.04.09
<b>Preliminary Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
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E	08.04.22	Reformat	KJ/JLM	
F	12.07.31	Dimensions updated per Dwg Rev C	KJ	[Signature]